

304.375

Work Order ID 86059

86059

Page 1

June-20-12 11:49:30 AM

Item ID: D3907-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bushing

Start Date: 20/06/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 27/06/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/20 Tooling:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3907

A

100

0.00

100

Hardinge

Memo

Hardinge CNC Lathe Small

Machine as per Folio FA823
& Dwg D3907

0.00

Dwg Rev: AA
folio Rev: 4
Deburr

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

Quality Control

0.00

DAS
14
2-83

12/07/16

41 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86059

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

2L 1207/18

120

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: WA

0.00

130

Packaging

Memo

0.00

Packaging

*****STOCK IN BASKET CELL*****

410

12/7/18

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/7/18

ME
12.07-18

Dart Aerospace Ltd

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NOTE: Date & initial all entries

Picklist Print

June-20-12 11:49:34 AM

Page 1

Work Order ID: 86059

86059

Parent Item: D3907-1

D3907-1

Parent Item Name: Bushing

Start Date: 20/06/2012

Required Date: 27/06/2012

Start Qty: 40.00

Required Qty: 40.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R0.375		Purchased	No			100	f	57.0920	0.03	1.2			

M304R0 375

304 ROUND BAR 0.375

**

Location

Loc Qty

Loc Code

MAT029

57.092

119346

1.564

120204

2.721

121380

4.807

→ 121728

48

1.2

OK 12/07/16

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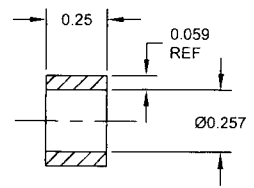
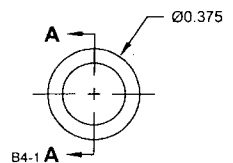
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SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

NO. 86059 MJS
12/06/20



D3907-1 BUSHING

SECTION A-A C5-1

RELEASED
9/10/11

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROD
 REF DART SPEC M304R
- OR: AISI 304/316 STAINLESS STEEL BAR
 REF DART SPEC M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

A	NEW ISSUE	AJS	09.03.11
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3907	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BUSHING (BASKET REPAIR)	NTS
DATE	09.03.11	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>ALL RIGHTS RESERVED. NO PART OF THIS PUBLICATION MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.</small>	

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